

Work Order ID 126905

December-01-14 10:03:51 AM

126905

Page 1

Item ID: D3793-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Fwd
 Start Date: 12/01/14 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 12/05/14 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3793	Rev A

100 0.00
 100 FLOW WATER JET
 Waterjet - Memo - 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3793 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary

110 0.00
 110 QC
 Quality Control Memo 0.00

120 0.00
 120 QC
 Quality Control Memo 0.00

DEC 01 2014

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Item ID: D3793-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Fwd
 Start Date: 12/01/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/05/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00			DAS 30 9-89	10			14/12/03
130									
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793								

140	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
140									
QC	Memo	0.00							
Quality Control									DEC 04 2014

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:20 FINISH TIME: 8:00 OVEN TEMPERATURE: 8.00								10 11-12-14 34 989

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Item ID: D3793-1 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 12/01/14 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 12/05/14 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

x10 of all data

170	Identify as per dwg & Stock Location: <u>170-002</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

x10 of all data

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

14/12/14

14-12-04

Picklist Print

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Work Order ID: 126905

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Parent Item: D3793-1

D3793-1

Parent Item Name: Wearplate Fwd

Start Date: 12/01/14

Required Date: 12/05/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	83.1653	0.5902	5			

M304S20GA

304/316 .040 Sheet

22 14/12/01

Location

Loc Qty

Loc Code

MAT020

83.1653

m130345

1.1319

m130745

82.0334

~~62.75~~ 10.3654

(2670)

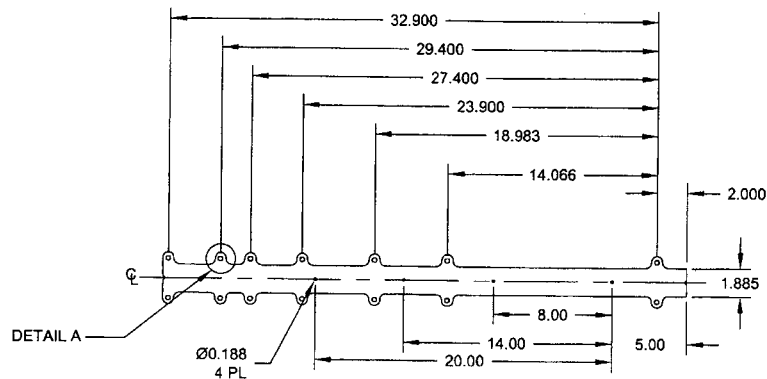
☒ **First Article** ☐ **Prototype**

~~DAS~~

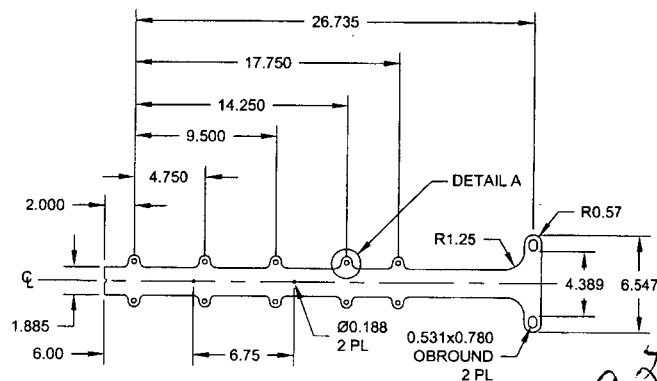
Dr / E /
14 / 12 / 01

Revised by	Approved
KJ/DD	

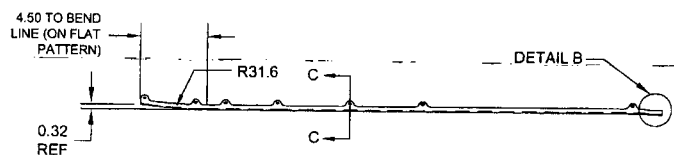
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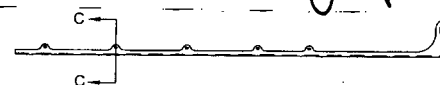
D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

Handwritten signature: wp 126905

RELEASED
08.05.14

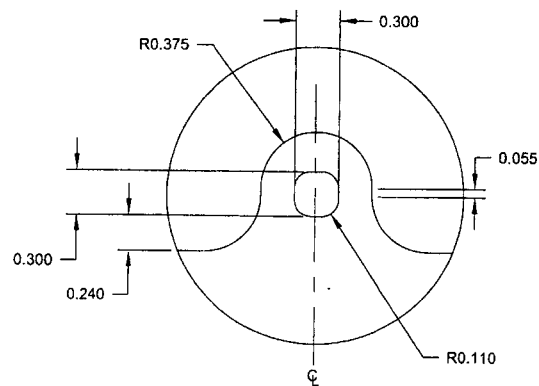
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

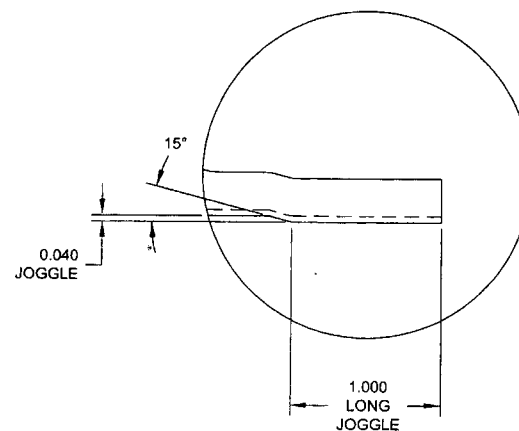
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CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
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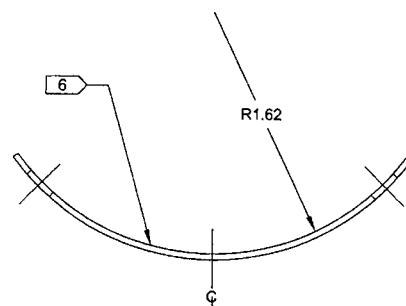
DETAIL A
SCALE 10X



DETAIL B
SCALE 10X

C

B



SECTION C-C
SCALE 10X

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08-05-23/ND

A

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